

Work Order ID 68616

Monday, April 18, 2011 3:25:50 PM

Split



Page 1

Item ID: D3016-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Frame Assembly

Start Date: 4/18/2011 Start Qty: *1.00*



Cust Item ID:

Required Date: 4/28/2011 Req'd Qty: *1.00*

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *11-04-18* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3016

RevA / DEO A-1

100



Large Fab

Large Fab

Weld per dwg A/R 4130 rod Batch: *M102226* 0.00

Large Fab

Memo

0.00

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig
DT8597

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

5- Assemble brackets and gusset per dwg and weld

EL 11-9-28 *(Signature)*

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

1 0 SE 1/05/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/02

~~1 11-5-02~~

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

Install paint screws on fitting ends
START TIME: 1:00
OVEN TEMPERATURE: 320°
FINISH TIME: 1:30

1 11-5-02

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 11/05/02

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location:

GA

0.00

Memo

0.00

w/o 68622

PB 4/05/03 @

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/3

P/11-05-3
①

W/O:		WORK ORDER CHANGES						
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Picklist Print

Monday, April 18, 2011 3:25:44 PM

Page 1

Work Order ID: 68616

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly



Start Date: 4/18/2011

Required Date: 4/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 01.09.19 New issue EC IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.049

Purchased

No

100

f

85.2300

4.3

4.526316



4130 RD Tube .750 x.049W

Location

Loc Qty

Loc Code

MAT033

85.23

10133

10.73

110740

74.5

M4130NT0.500W.049

Purchased

No

100

f

81.8400

4.3

4.526316



4130 RD Tube .500 x.049W

Location

Loc Qty

Loc Code

MAT032

81.84

106651

7.09

110740

74.75

M4130NT1.000W.120

Purchased

No

100

f

11.2200

1.5

1.578947



4130 RD Tube 1.00 x .120wall

Location

Loc Qty

Loc Code

MAT033

11.22

113665

1.22

117372

10

D3016-17

Manufactured

No

100

Each

6.0000

2

2



Gusset

Location

Loc Qty

Loc Code

WA019

6

64618

6

66736

2

2

EL 11-4-28

EL 11-4-27

8.25'

EL 11-4-27

8.2'

EL 11-4-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, April 18, 2011 3:25:45 PM

Page 2

Work Order ID: 58616

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 4/18/2011

Required Date: 4/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3016-13

Manufactured No

100

Each

14.0000

2

2



Bracket



EL 11-4-28

Location

Loc Qty

Loc Code

WA019

14

44778

14

4

D3016-15

Manufactured No

100

Each

5.0000

2

2



Gusset



EL 11-4-28

Location

Loc Qty

Loc Code

WA019

5

43413

5

1

68735 x 3

D3020-1

Manufactured No

100

Each

33.0000

4

4



Fitting



EL 11-4-28

Location

Loc Qty

Loc Code

WA

33

36713

33

4

Monday, April 18, 2011 3:25:45 PM

Shop Packet Print

Page 2

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEO ATTACHED

RELEASED
01.05.30

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

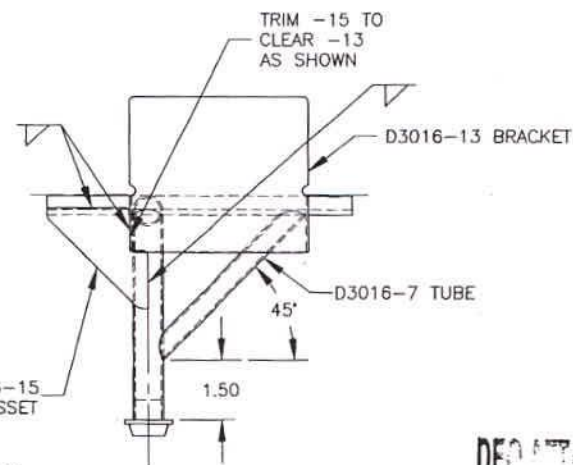
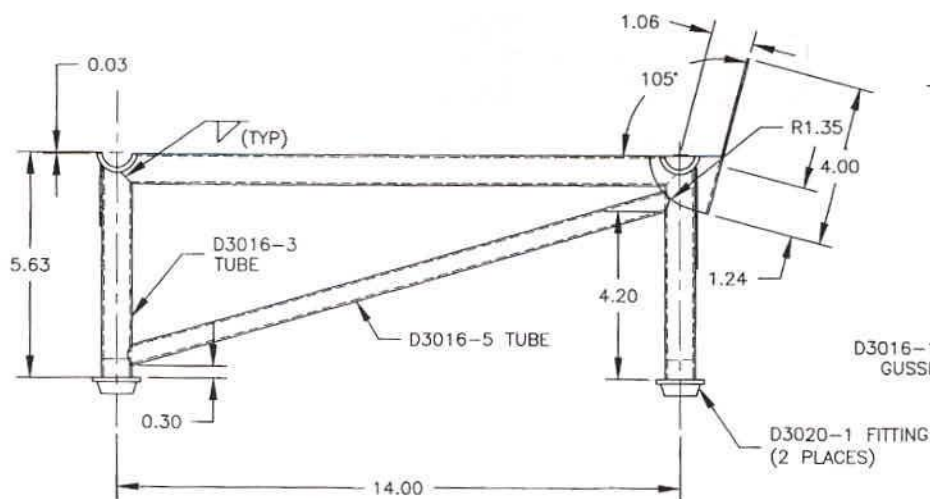
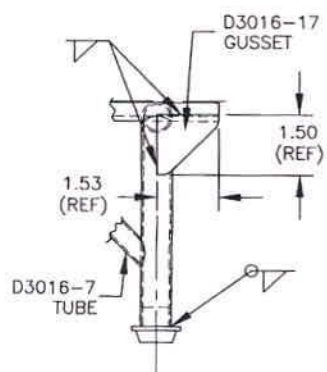
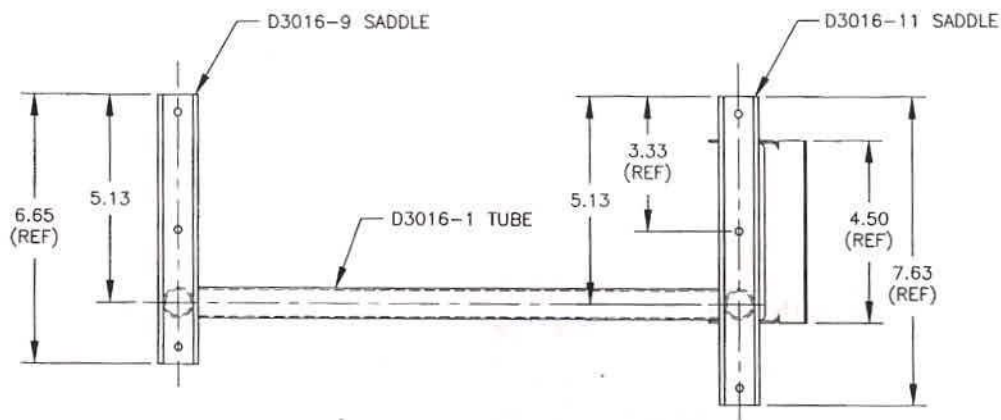
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NOTE: Date & initial all entries

D3016-041 SEAT FRAME ASSEMBLY



DETACHED
RELEASED
01.05.30

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DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY		SCALE 1:3		

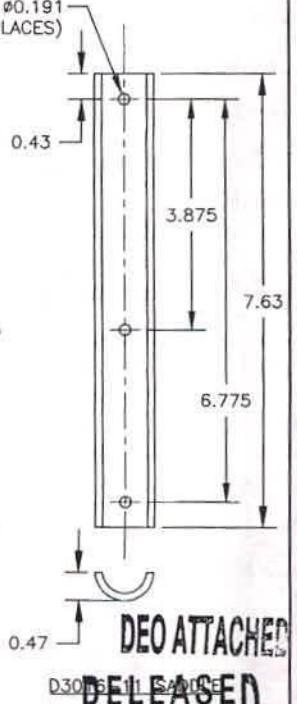
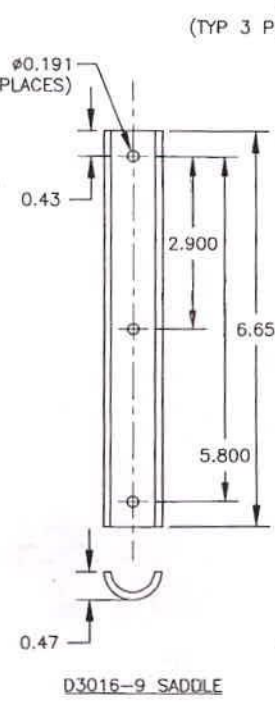
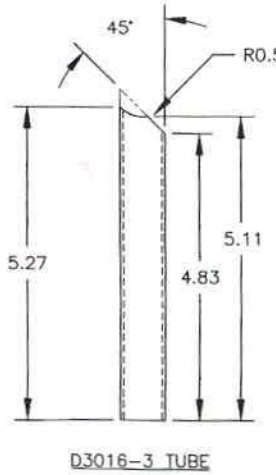
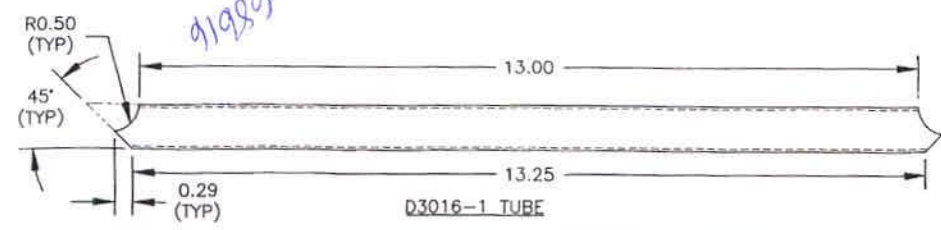
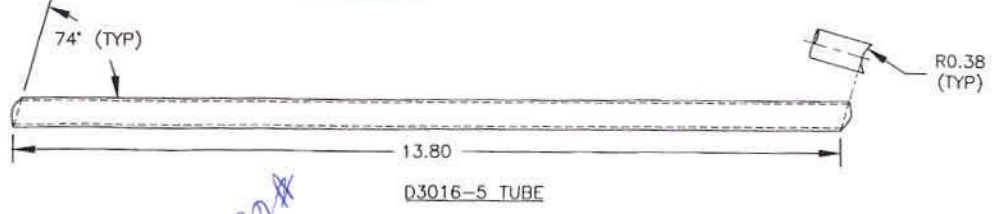
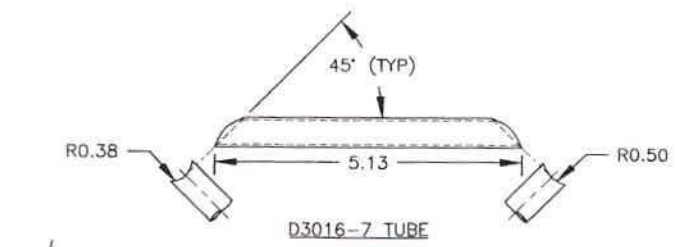
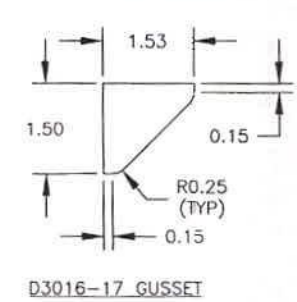
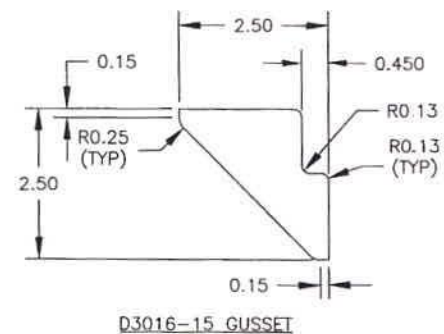
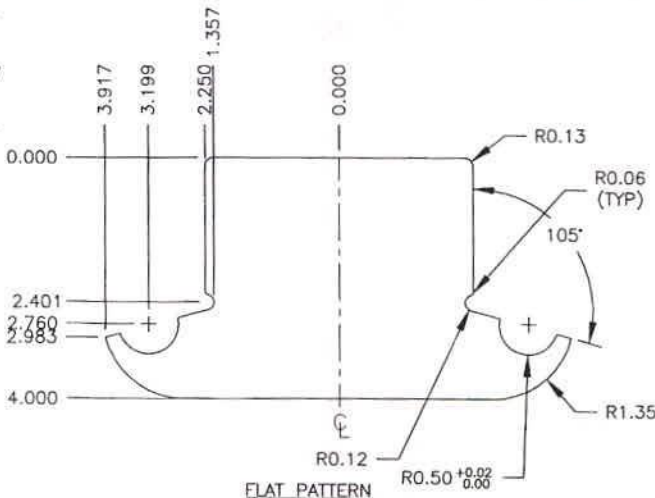
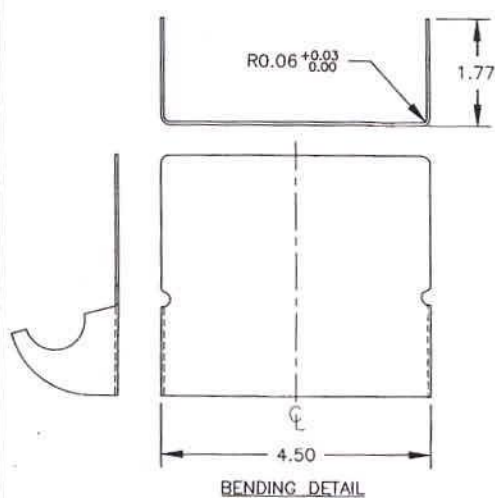
W/O:		WORK ORDER CHANGES						
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				DATE		DRAWING NO.	REV. A
				01.05.18		D3016	SHEET 3 OF 3
						TITLE	SCALE
						SEAT FRAME ASSEMBLY	1:2

DEO ATTACHED
RELEASED
01.05.30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 1	CHECKED 17	MFG. APPR. RE	APPROVED WAP	DE APPR. WAP		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		

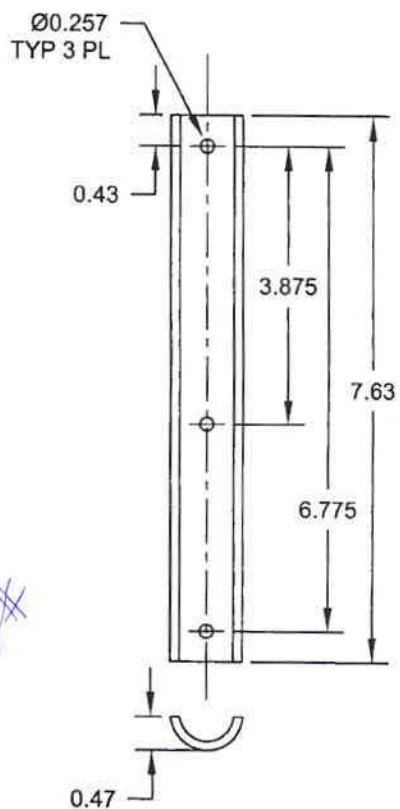
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

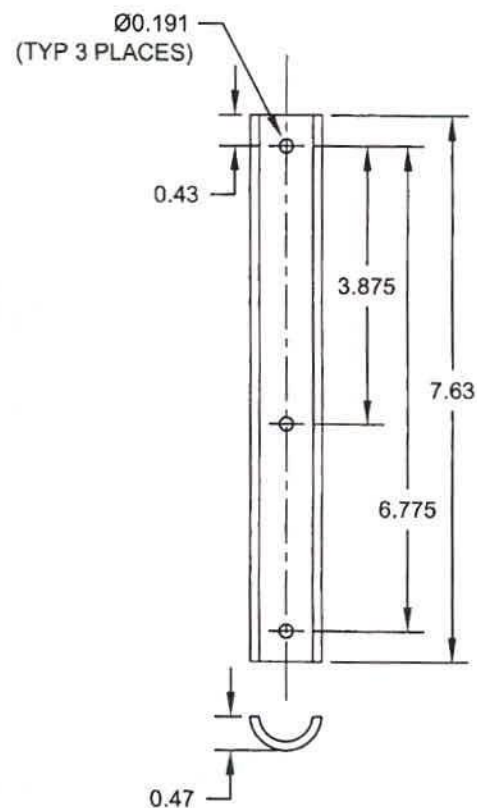
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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